

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016372**Date Inspected:** 22-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 04, Deck Panel 14E-DP3161(PL3437A)-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3161(PL3437A)-001, 4 ribs, 8 welds, 188 total tack welds inspected.

Weld 1 scanned 24 locations with 2 indication.

Weld 2 scanned 23 locations with no indications.

Weld 3 scanned 23 locations with no indications.

Weld 4 scanned 24 locations with 1 indication.

Weld 5 scanned 24 locations with no indications.

Weld 6 scanned 23 locations with no indications.

Weld 7 scanned 23 locations with no indication.

Weld 8 scanned 24 locations with no indications.

Subassembly, Bay 04, Deck Panel 14E-DP3161(PL3437B)-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found

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with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3161(PL3437B)-001, 4 ribs, 8 welds, 64 total tack welds inspected.

Weld 9 scanned 8 locations with 1 indication.

Weld 10 scanned 8 locations with no indications.

Weld 11 scanned 8 locations with 2 indications.

Weld 12 scanned 8 locations with no indication.

Weld 13 scanned 8 locations with no indications.

Weld 14 scanned 8 locations with 1 indications.

Weld 15 scanned 8 locations with 1 indication.

Weld 16 scanned 8 locations with no indications.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel carrying out Weld repairs after visual testing on Deck panel to U-rib welds of Deck Panel DP3086-001. Repair carried out with Flux core arc welding (FCAW). Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Welds & Approximate Y-locations of repair were;

W116 – 50, 1150mm.

W111 – 50mm.

W003 – 650mm.

W005 – 650mm.

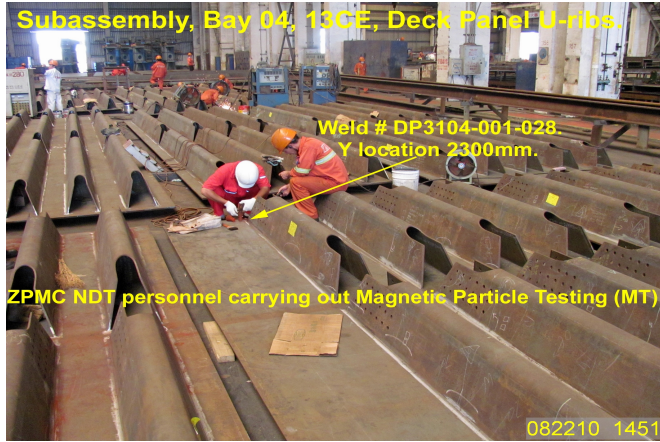
Subassembly, Bay 04, 13CE, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel “Yuan Tao” carrying out Magnetic Particle Testing (MT) on Deck panel to U-rib welds. Deck Panel identified as DP3104-001. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Juvekar,Amit | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
